

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008218**Date Inspected:** 30-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu yang/ Mr. Xu le feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 068916 perform FCAW welding on, south tower, Lift 4, Doublers plate, Weld joint no. SSD1-FESA4-1 E/F-3. ZPMC CWI Identified as Mr. Shi wei song. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4332-tc-p4-f.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066328 perform FCAW Buttering welding (15mm) on, South tower, Lift 2, interconnecting splice. ZPMC CWI Identified as Mr. Li ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-3G (3F)-Repair. Refer photograph.

Bay no. 11

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040699 perform SAW welding on, East tower, Skirt plate, Weld joint no. ESD1- A 435 A/C-3B. ZPMC CWI Identified as Mr. Zhan bo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-b-u3c-s2.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040775 perform FCAW welding West tower, Lift 4, Weld joint no.WSD1-FASA4-2 E/E-93A. ZPMC CWI Identified as Mr. Li Ling. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-TC-U5-F.

5.This QA inspector, Baskar Govindarajan, observed, Parent metal damage of 6 mm depth in cut edge of Doublers plate, identified as DB-4-18 in West tower, Skin A. ZPMC CWI Identified as Mr. Li bin. The parent metal thk. found to be 50 mm thk.The Welding repair report found to be T-WR-1853. Refer photograph.

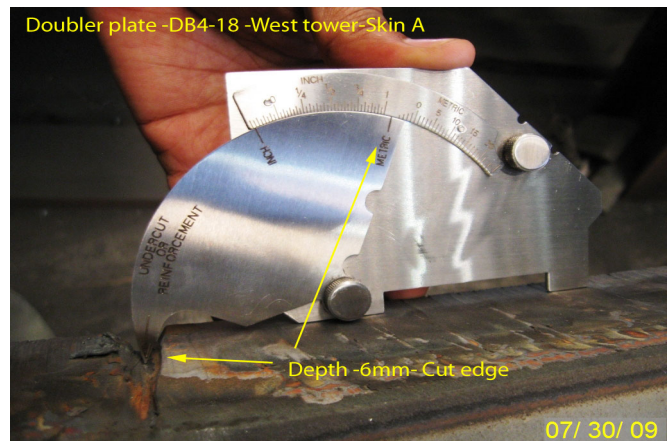
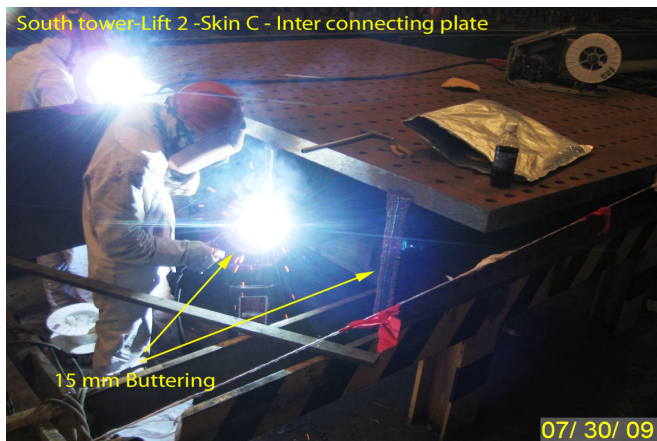
Magnetic Particle Testing:

For Green Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date. The member and the weld designations are as follows:

Sl #	Section #	Weld
1.	Lift 4, South skin B, Filling plate	SSD1-FBSA4-1A/C-80, 81, 82, 83 A/B

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials

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for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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